

Date: Thursday, 8/30/2007 3:49:46 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SUPPORT |
| Job Number | : 34351A | | |
| Estimate Number | : 10452 | | |
| P.O. Number | : <u>N/A</u> | Part Number | : D32781 |
| This Issue | : 8/30/2007 | S.O. No. | : <u>N/A</u> |
| Prsht Rev. | : NC | Drawing Number | : D3278 REV. B |
| First Issue | : <u>N/A</u> | Project Number | : N/A |
| Previous Run | : 34006A | Drawing Revision | : <u>XC</u> |
| | | Material | : <u>N/A</u> |
| Written By | : | Due Date | : 9/21/2007 |
| Checked & Approved By | : | Qty: | 20 Um: Each |
| Comment | : Est:A 04.04.19 Newissue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1000X02000 | 6061-T6 Bar 1.0" x 2.0" |
|-----|--------------------|-------------------------|



PTO →

Comment: Qty.: 0.2454 f(s)/Unit Total: 4.9077 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M104187

J.F. 07/09/24 (20)

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

J.F. 07/09/24 (20)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

J.F. 07/10/02

J.F. 07/09/28

(20)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/09/28

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.F. 07/10/02

(20)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D 3278-1 PAR #: N/A Fault Category: Prod / Machine B13 NCR: Yes No DQA: 2 Date: 07/10/04
 QA: N/C Closed: 18 Date: 07.10.04

| NCR: <u>34351A</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------------|------|--|--------------------------------|--|------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/09/28 | 3 | 4 piece's are scrap. Having problem with the fixture causing the parts to lift, and machining them too thin. | <i>[Signature]</i> 05/10/02 | Scrap, destroy & replace. Qty 4. re-machine fixture. | J.F. 07/09/28 | <i>[Signature]</i> 07-10-02 | <i>[Signature]</i> 05/10/02 | <i>[Signature]</i> 07-10-02 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 34351A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/10/03 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PH 07-10-03

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Le 7/10/04 20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 73

Le 7/10/04 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) 07/10/04

Job Completion



U 07-10-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|-----------------------|-----------------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Support | | Part Number: | D3278-1 |
| Inspection Dwg: D3278 | Rev: <i>B C</i> | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|----------|--------|----------------------|----------|
| <i>Ø0.098</i> | +0.005/-0.000 | <i>Ø.098"</i> | <i>✓</i> | | | |
| 0.359 | +/-0.005 | <i>.360"</i> | <i>✓</i> | | | |
| <i>0.612"</i> | +/-0.010 | <i>.612"</i> | <i>✓</i> | | | |
| 0.250 | +/-0.010 | <i>.251"</i> | <i>✓</i> | | | |
| 1.480 | +/-0.005 | <i>1.481"</i> | <i>✓</i> | | | |
| R0.125 | +/-0.010 | <i>R0.125"</i> | <i>✓</i> | | | |
| 0.119 | +0.005/-0.004 | <i>.116"</i> | <i>✓</i> | | | |
| 2.439 | +/-0.010 | <i>2.438"</i> | <i>✓</i> | | | |
| 1.980 | +/-0.010 | <i>1.977"</i> | <i>✓</i> | | | |
| R0.130 | +/-0.010 | <i>R0.130"</i> | <i>✓</i> | | | |
| Ø0.257 | +0.005/-0.000 | <i>Ø.258"</i> | <i>✓</i> | | | |
| R0.375 | +/-0.010 | <i>R.377"</i> | <i>✓</i> | | | |
| 0.875 | +/-0.010 | <i>.875"</i> | <i>✓</i> | | | |
| 0.500 | +/-0.010 | <i>.500"</i> | <i>✓</i> | | | |
| R0.400 | +/-0.010 | <i>R0.400"</i> | <i>✓</i> | | | |
| 1.720 | +/-0.010 | <i>1.719"</i> | <i>✓</i> | | | |
| R0.125 | +/-0.010 | <i>R0.125"</i> | <i>✓</i> | | | |
| 0.125 | +/-0.010 | <i>.122"</i> | <i>✓</i> | | | |

| | | | |
|--------------------------|-------------------------|---------------------|-----|
| Measured by: <i>J.F.</i> | Audited by: <i>J.L.</i> | Prototype Approval: | N/A |
| Date: <i>07/09/28</i> | Date: <i>07/09/28</i> | Date: | N/A |

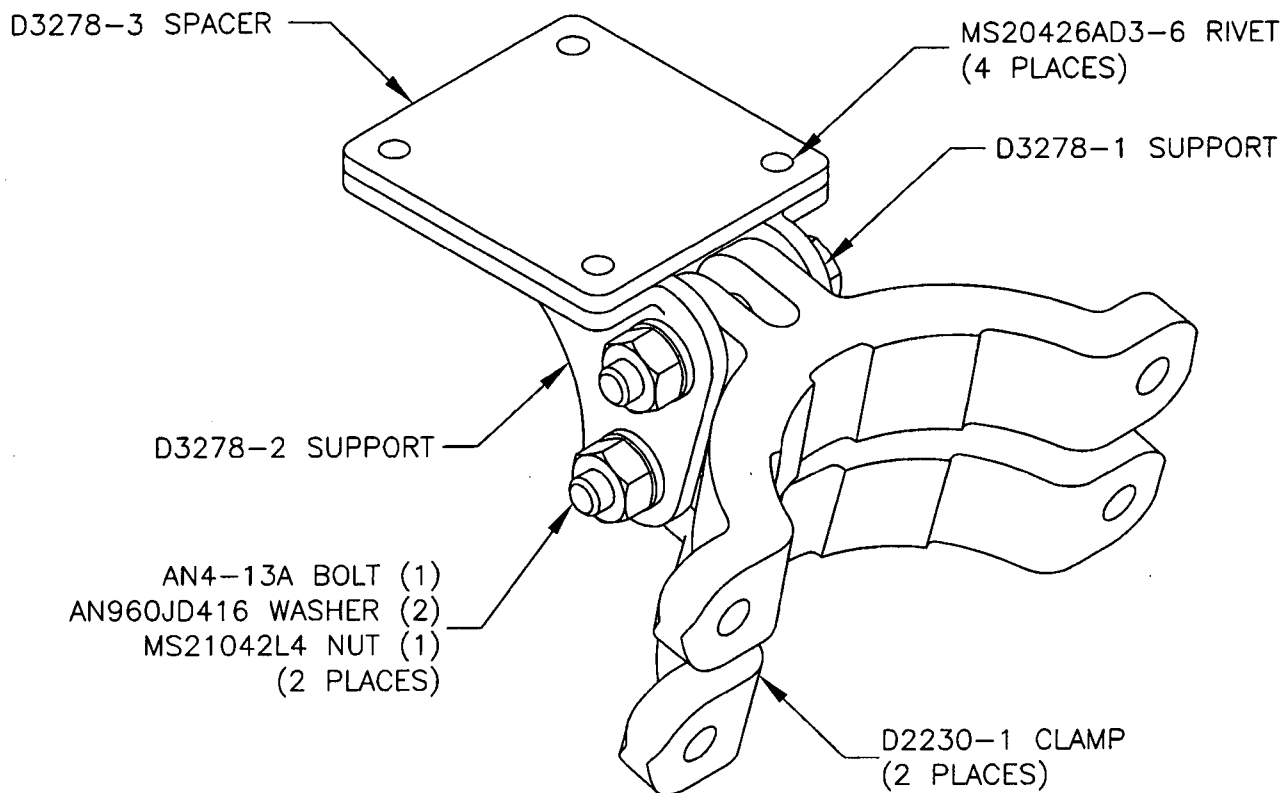
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------------|-----------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM <i>JA</i> | <i>JA</i> |



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN 97 | DRAWN BY JC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED H | DRAWING NO. D3278 | REV. C SHEET 1 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE NTS |
| A | 04.03.03 | NEW ISSUE | |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT | |
| C | 07.07.24 | CHANGED RIVETS PER PAR #185 | |

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY

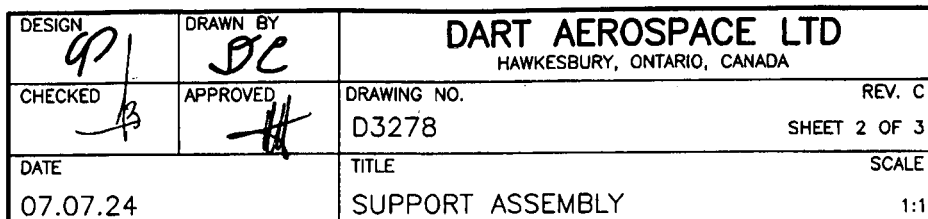


| Qty | Part Number | Description |
|-----|--------------|------------------|
| X | D3278-041 | SUPPORT ASSEMBLY |
| 2 | D2230-1 | CLAMP |
| 1 | D3278-1 | SUPPORT |
| 1 | D3278-2 | SUPPORT |
| 1 | D3278-3 | SPACER |
| 2 | AN4-13A | BOLT |
| 4 | AN960JD416 | WASHER |
| 4 | MS20426AD3-6 | RIVET |
| 2 | MS21042L4 | NUT |

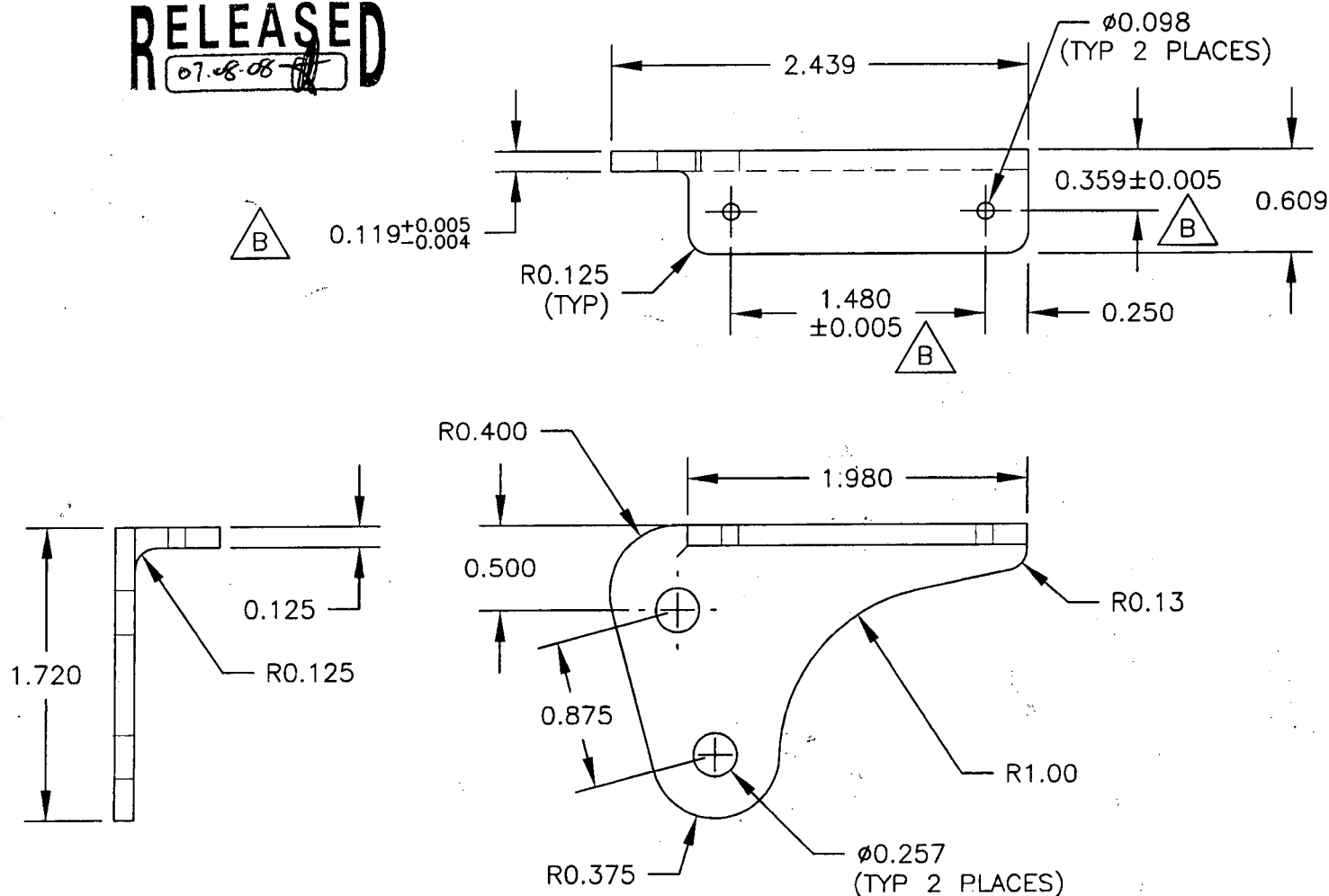
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RELEASED
07-08-08



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

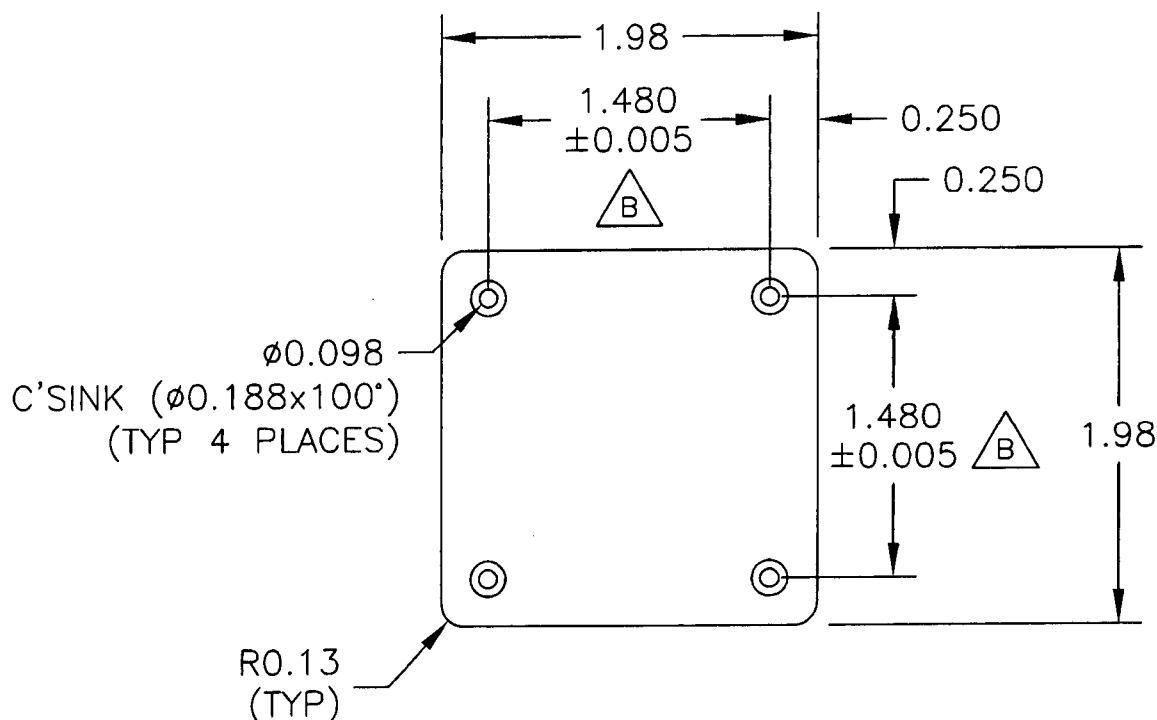
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DART

| | | | |
|------------------|---------------------------|---|------------------------|
| DESIGN 9P1 | DRAWN BY BC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED [Signature] | DRAWING NO. D3278 | REV. C SHEET 3 OF 3 |
| DATE 07.07.24 | TITLE SUPPORT ASSEMBLY | | SCALE 1:1 |

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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